



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13143	40/50
2	Machined By		V. T. L n/c Shop	Dy. No. 13.0.450
3	Pallet Die No.		12753(4.0)mm	
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730mm Step OD = 743.4mm	Tappers 10°
6	Inside Diameter	Drg. No.	630.12mm	Step length 23mm
7	Width of Pellet Die	Drg. No.	290mm	Under cut 6.75mm
8	Grooves as per Drawing	Drg. No.	15x8x5mm / 15x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		685mm	Tapping No. of holes 16 Both Side
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 19.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/11/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5mm	outside (3.3)		Inner			
3	External Relief Depth	/	14mm		10mm			
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		4	11	24			

### Inspected By (Sign) & Date

Ravi 4/11/24

4/11/24

Reviewed by (Engineer-CNC)

Manager-QA